

Date: Wednesday, 2/1/2006 11:38:06 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : STEP INSTALLATION RH (FOLDING)  
 Job Number : 25705  
 Estimate Number : 11451  
 P.O. Number : N/A Part Number : D412630014  
 This Issue : 2/1/2006 S.O. No. : N/A Drawing Number : D2801 REV A1  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : LARGE FAB ASSY Drawing Revision : A1  
 Previous Run : 25221 Material : N/A  
 Due Date : 3/10/2006 Qty: 2 Um: Each  
 Written By : See COMMENT Below  
 Checked & Approved By : 06.02.01  
 Comment : Est Rev:E 04.05.17 Reformat; Removed AN3-16A KJ/RF

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D412-630-014 CHG004

DH 06/02/15

2.0 D2622120C Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Qty Part # Description Batch:

1 D2622-120C Extrusion 524092

Check Material for any Dents or Defects

P.E. 06.02.13 = 2

3.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2622 extrusion to 86.15" long as per Dwg D2801

2-Deburr and bevel ends for welding

P.E. 06.02.13 = 2

4.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06.02.13 = 2  
06/02/14 = 2

5.0 D2734 206 Step Endplate



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

P.E. 06.02.14 = 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 25705

Part Number: D412630014

Job Number:



Seq. #:

Machine Or Operation:

Description :

2 D2734

End Cap

B20757

*S.L. 06-02-13 = 2*

6.0

D28022

Arm



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 D2802-2

Arm

B15739 <sup>①</sup> & B25709 <sup>③</sup>

*S.L. 06-02-14 = 2*

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld arms and end caps as per Dwg D2801 & QSI 004. Inspect for foreign objects as per QSI 024.

A/R Aluminum Rod M18839 & M18838

2-Grind end cap welds flush as per Dwg D2801

*S.L. 06-02-14 = 2*

8.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

*S.L. 06-02-14 = 2*

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*SAD 06-02-14*

*2*

*PT*

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

*a.m 06-03-01*

*②*

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D2801 and QSI 005 4.4

Batch: M100037

*FL 06 03 01*

*②*

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
06.02.21	9b	pick end plate & de burr for welding	LE	06.02.21	2	Y		
06.02.21	9c	weld end plate as per dwg. d2801 and Q51.004	LE	06.02.21	2			
06.02.22	9d	grind end plate flush as per dwg 2801	FF	06.02.22	2			
		<del>inspect work to current STEP</del>	LE	06.02.22	2			
06.02.22	9e	inspect work to current STEP QC 5.09. 06.02.22	FF	06.02.22	2	06.02.22		
06.02.22	9f	and for foreign objects. PD 06.02.23	FF	06.02.24	2			
06.02.22	9f	Chemical corrosion coat end plate on step AS per Q51.005 4.1.	FF	06.02.24	2			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/03/20

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Machine Or Operation:

Description :

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Assembly Kit

14.0

D2012107

Clevis



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2012-107

Clevis B25483

15.0

D2022101

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 D2022-101 Spacer B23396

16.0

D2652

Bushing



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description Batch

4 D2652

Bushing B22319

17.0

D2803044

STA 84 Bracket Ass'y RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2803-044 Bracket Assembly

B19114

18.0

D2804044

STA 155 Bracket Ass'y RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2804-044 Bracket Assembly

B25711

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

D2807

Support Prop



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 D2807

Gas Spring B23915

20.0

D2808

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 D2808

Bushing B22862

21.0

D28101

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2810-1

Strut B25712

22.0

D2813

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 D2813

Washer B24623

23.0

AN320A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 AN3-20A

Bolt M15432

24.0

AN3108

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 AN310-8

Nut M9634

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number:



Seq. #:

Machine Or Operation:

Description :

25.0

AN410A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

QPick:

Qty Part Number

Description Batch

1 AN4-10A

Bolt

M180 57

26.0

AN816

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 AN8-16

Bolt

M18615

27.0

AN960JD10

Washer



Comment: Qty.: 5.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number

Description Batch

5 AN960JD10

Washer

M19521

28.0

AN960JD416

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 AN960JD416

Washer

M19085

29.0

AN960JD816

1/2" washer, Alum



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description Batch

4 AN960JD816

Washer

M6956

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Drawing Name: STEP INSTALLATION RH (FOLDING)

Job Number: 25705

Part Number: D412630014

Job Number:



Seq. #:

Machine Or Operation:

Description :

30.0

MS21042L3

Nut



Comment: Qty.: 5.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number

Description Batch

5 MS21042L3 Nut (or -3) 18917

31.0

MS21042L4

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 MS21042L4 Nut (or -4) M17997

32.0

MS24665285

Cotter Pins



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 MS24665-285 Cotter Pin M2421

33.0

MS24693S280

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 MS24693-S280 Screw M8649

34.0

AN316A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 AN3-16A Bolt M17073

JAN

05:03:15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 25705

Part Number: D412630014

Job Number:



Seq. #:	Machine Or Operation:	Description :
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35.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1  
Assemble as per Dwg D412-630

540 0250316

2

36.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

02-03-16

37.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1  
Pick Packing Kit

38.0	D2012107	Clevis
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Pick: Packing Kit  
Qty Part Number Description Batch  
1 D2012-107 Clevis B205483 ✓

39.0	D2022101	Spacer
------	----------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)  
Pick: Packing Kit  
Qty Part Number Description Batch  
2 D2022-101 Spacers B23396 ✓

40.0	D28061	Bushing
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)  
Pick: Packing Kit  
Qty Part Number Description Batch  
2 D2806-1 Bushing B23629 MCP B24621 3my ✓

41.0	D28063	Bushing
------	--------	---------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)  
Pick: Packing Kit  
Qty Part Number Description Batch  
2 D2806-3 Bushing B205810 ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 25705

Part Number: D412630014

Job Number:



Seq. #:

Machine Or Operation:

Description :

42.0

AN46A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 AN4-6A

Bolt M19278 ✓

43.0

AN410A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 AN4-10A

Bolt M18057 ✓

44.0

AN415A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 AN4-15A

Bolt M19085

~~A-1515A~~

45.0

AN515A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 AN5-15A

Bolt ~~M18085~~

~~A-1515A~~

M18279

46.0

AN960JD416

Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 AN960JD416

Washer M19085 ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 25705

Part Number: D412630014

Job Number:



Seq. #:

Machine Or Operation:

Description :

47.0

AN960JD516

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN960JD516 Washer M18254 -

48.0

MS21042L4

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 MS21042L4 Nut (or -4) M19099 -

49.0

MS21042L5

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 MS21042L5 Nut (or -5) M19073 -

50.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

51.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-630-014

Location: B

PPP Rev: B

52.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



u 06.03.20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

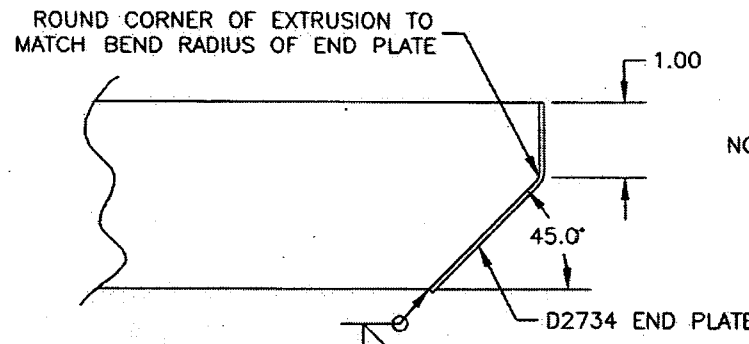
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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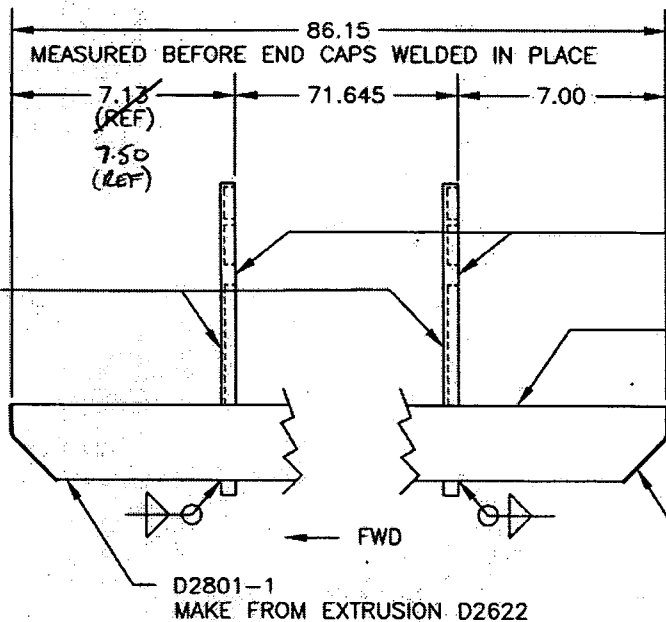
**DART**

QA COPY ISSUED



NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004

TYPICAL STEP END DETAIL  
NOT TO SCALE



D2802-041 ARM  
(2 PLACES)  
USE D2802-042  
FOR D2801-042  
RH STEP ASSY

POCKET SIDE  
APPLY BLACK  
ANTI-SKID ON  
TOP SURFACE  
TO BOTTOM  
OF TOP RADIUS

REFER TO STEP  
END DETAIL

D2801-041 LH STEP ASSEMBLY (SHOWN)  
D2801-042 RH STEP ASSEMBLY (OPPOSITE)

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
WELD PER DART QSI 004 UNLESS OTHERWISE NOTED  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT ENTIRE ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)  
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 25705  
SHOP  
RETURN TO  
ENGINEERING

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DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. A
CHECKED	APPROVED	DRAWING NO. D2801	SHEET 1 OF 1
DATE 00.11.03	00.11.03	TITLE STEP WELDMENT	SCALE NTS
A1	03.08.15	NEW ISSUE	

RELEASED  
00.11.13